

in that the metal strip (16) is merely reduced in thickness, but not yet profiled, in a first rolling step.

25. (Currently Amended) The method as defined in Claim 42 1, characterised by the use of a roll stand (2) in which at least one of the two rollers (12) comprises in its shell surface a profiled segment (35, 40) with a contour which, in combination with the contour of the other roller (11), defines the roll gap (13).

27. (Currently Amended) The method as defined in Claim 42 1, characterised in that one roller (12) of the roll stand (2) is displaced during the rolling process of the metal strip (16) for varying the height of the roll gap (13).

44. (Currently Amended) A device having a roll stand (2) with two rollers (11, 12) that define a roll gap (13) the height of which can be varied,

and with a recalling device (5, 52) for a metal strip (16) to be rolled, arranged on the run-in end of the roll gap (13),

for producing a strip-like pre-material from metal, with a profile which recurs in successive sections of the pre-material, according to the method defined in Claim 42 1.

for which purpose the first (11) and/or the second roller (12) are provided on their shell surface with two or more than two circumferential segments (35, 36, 40), following each other in the circumferential direction, which are not all of them equal in contour,

and for which purpose a drive motor (7, 54) is provided for the recalling device (5, 52) arranged on the run-in end of the roll gap (13), for recalling the metal strip (16) by steps of predetermined length.

Cancel claims 64-71

72. (Currently Amended) The device as defined in Claim 60 or 64 44, wherein an electric control unit (43) is provided in which the displacement of the one roller (12) required for an intended profile is, preferably, digitally stored as curve and wherein the servomotors (7, 8; 54, 55) of the recalling device (5, 52) and of the pulling device (6, 53), one or two servomotors (41, 42) for rotating the two rollers (11, 12), and one or more actuating drives (32, 33, 34) for the displaceable roller (12) coupled with an incremental rotary transducer (44), are connected to said control unit (43).

73. (Currently Amended) The device as defined in Claim 44 or 64 or 65 or 72,

wherein the sense of rotation of the two rollers (11, 12) can be reversed for rolling in both directions.

Add new claim 75 as follows:

75. (New) The method as defined in Claim 20, characterized in that the metal strip (16) is equalised in the first rolling step.

**PLEASE NOTE: A complete listing of the claims as well as new pages 1, 2, 4, 11, and 15-17 and the Abstract follow the signature page of this amendment.**